

Date: Monday, 11/19/2007 4:02:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 35824	
Estimate Number : 11209	
P.O. Number : <u>N/A</u>	Part Number : D31701
This Issue : 11/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3170 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 26686	Material : <u>Z3</u>
Written By : <u>[Signature]</u>	Due Date : 11/23/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A 02.10.11 New issue KJ	
Est Rev: B 06-04-27 Manufactured in House JLM	
Est Rev: C Now 6061-T6 06-06-23 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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2.751



Comment: Qty.: 0.0655 sf(s)/Unit Total : 1.3104 sf(s)  
 Material: 6061T6 0.080" thick  
 (M6061T62S.080)  
 Batch: D0434 1807-11-20

2.0	WATER JET	FLOW WATER JET
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(P12) →

Comment: FLOW WATER JET  
 1-Cut as per Dwg D3170  
 Dwg Rev: B 1807-11-20  
 Prog Rev: B  
~~2-Debur if necessary~~ → 1807-11-20

(42)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Debur

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

F2 07/11/21 (42)

23 Inspect QC #2 (1807-11-21) (x42)  
 24 Inspect QC #2 (11/11/21) (x42) notes

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/11/21	2.1 2.2	ADD A QC # 21 <sup>inspection level</sup> <del>at</del> Step #2.1 and ADD A QC # 8 inspection level <del>at</del> before step 3.0		07/11/21			 07/11/21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:02:03 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 35824

Part Number: D31701

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A  
12/11/23



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Pat E



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W44

12-11-23

42

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(42)

Comment: FINAL INSPECTION/W/O RELEASE

12/11/23

Job Completion



12/11/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

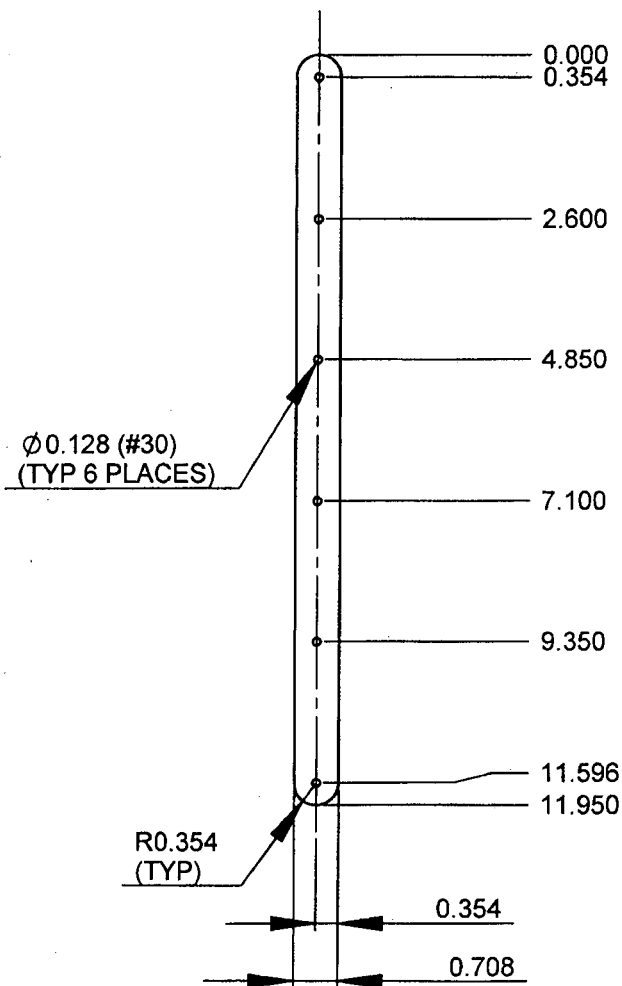
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3170</b>	REV. B SHEET 1 OF 1
DATE <b>06.05.30</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.30	ADD 6061-T6 MATERIAL	

**RELEASED***06.05.30***D3170-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK  
(REF DART SPEC. M5052H32S.080)

- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) PART IS SYMMETRIC ABOUT CENTERLINE  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35824*

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